

Work Order ID 86166

June-21-12 2:29:50 PM

86166

Page 1

Item ID: D4016-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Half, Base

Start Date: 21/06/2012 Start Qty: 18.00 ***18***

Cust Item ID:

Required Date: 27/06/2012 Req'd Qty: 18.00 ***18***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/21

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4016

A

100

Cut blanks as per folio

0.00

100

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 1.00" LONG

0.00

FK 12/07/18

44

Ø

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA869 AND DWG

FOLIO REV: AB

DWG REV: A

0.00

DEBURR

OK 12/07/20

44

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC: _____

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SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130 QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

160 Identify as per dwg & Stock Location: ST 44 0.00

160

Packaging

Memo

0.00

Packaging

ant / 12/07/20

SL 12-07-21

44

44X

SD 12-7-23

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Page 3

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Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____


Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/7/23 mc
12-07-23

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-21-12 2:29:55 PM

Page 1

Work Order ID: 86166

86166

Parent Item: D4016-1

D4016-1

Parent Item Name: Hinge Half, Base

Start Date: 21/06/2012

Required Date: 27/06/2012

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B
as per dwg REV.A DD 10:02:22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	34.0270	0.08	1.44			

M304B1 000X1 000

304 bar 1.00 x 1.00

Location

Loc Qty

Loc Code

MAT050

34.027

113290

1.047

121806

20.4

122008

12.58

3.52 ~~1.44~~

FK 12/07/18

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DART AEROSPACE LTD		Work Order:	86166
Description: Hinge Half, Base		Part Number:	D4016-1
Inspection Dwg: D4016 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.875	+/-0.010	.876			SLO8	VerN
0.25	+/-0.030	.244			↓	
0.38	+0.030/-0.000	.390				
R0.03	+/-0.030	.030				
0.13	+/-0.030	.125				
0.88	+/-0.030	.878				
Ø0.257	+0.006/-0.001	.259				
R0.38	+/-0.030	.380				
0.500	+/-0.030	.500				
0.75	+/-0.030	.752				

Measured by:	SL	Audited by:	SL	Preliminary Approval:	
Date:	12/07/20	Date:	12-07-21	Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



12/06/20

RELEASED
2010-02-16
md

A	NEW ISSUE		JPH	10.01.29
REV.		DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4016 TITLE BASKET HINGE		
DRAWN	AJS			
CHECKED	<i>GO</i>			
MFG. APPR.	<i>RS</i>			
APPROVED	<i>NO</i>			
DE APPR.	<i>Alt</i>			
DATE	10.01.29			

REV. A
 SHEET 1 OF 2
 SCALE
 NTS

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Dart Aerospace Ltd

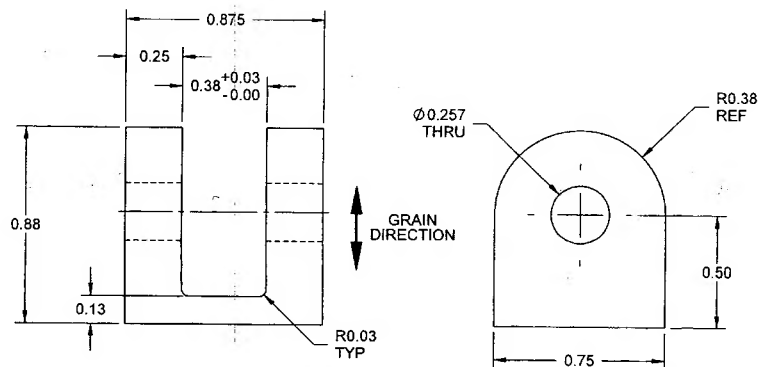
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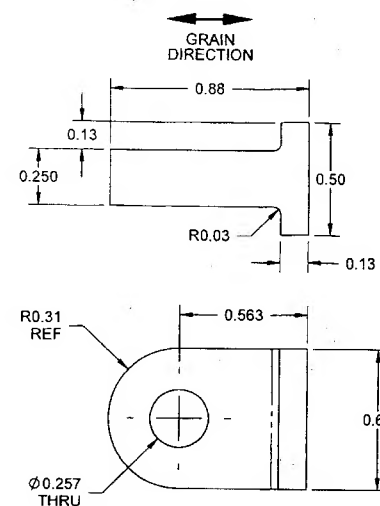
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D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

RELEASED
2010-02-16
M

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4016	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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